



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D3601-1**  
**Job Sheet 170866**



Part No: D3601-1

Job Qty: 200 ea

*207*

Part Name: Radius Block



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/23/18

Job Tracking No:

Due Date: 1/31/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 07-03-28 JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty     | Start Date | Due Date | Standard |      | Workcenter/Supplier   |           | Sign-off   |
|-------|------------------------|---------|------------|----------|----------|------|-----------------------|-----------|------------|
|       |                        |         |            |          | Setup    | Run  | Workcenter / Supplier | Lead Time |            |
|       |                        |         |            |          | hrs      | Hrs  |                       |           |            |
| 90    | Start up Operation     | 200 Ea  |            | 1/30/18  | 0.00     | 0.00 | Start Up Machining-4  |           | <i>llm</i> |
| 100   | Shear                  | 200 pcs |            | 1/30/18  | 0.00     | 1.46 | Shear                 |           | <i>llm</i> |
| 110   | CNC Vertical Machining | 200 pcs |            | 1/30/18  | 0.01     | 6.69 | HAAS1-4               |           | <i>llm</i> |
| 120   | QC                     | 200 pcs |            | 1/30/18  | 0.00     | 0.00 | QC2 Machining-2       |           | <i>llm</i> |
| 130   | QC                     | 200 pcs |            | 1/30/18  | 0.00     | 0.00 | QC8 Machining-2       |           | <i>llm</i> |
| 140   | Small Fab              | 200 pcs |            | 1/30/18  | 0.00     | 1.39 | Small Fab-4           |           | <i>llm</i> |
| 150   | HandFinish             | 200 pcs |            | 1/31/18  | 0.00     | 0.89 | HandFinish1           |           | <i>llm</i> |
| 160   | QC                     | 200 pcs |            | 1/31/18  | 0.00     | 0.00 | QC7-5                 |           | <i>llm</i> |
| 170   | Packaging              | 200 pcs |            | 1/31/18  | 0.00     | 0.00 | Packaging3-1          |           | <i>llm</i> |
| 180   | QC21-SA                | 200 Ea  |            | 1/31/18  | 0.00     | 0.00 | QC21                  |           | <i>llm</i> |

Part Op 100 - blanks 9.00" long +/- 0.030" Note: 1 blank makes 8 pieces

Descriptions: 110 - 1- Mill as per Folio FA682 Rev: \_\_\_\_\_ & Dwg D3601 Rev: \_\_\_\_\_

140 - 1-Tumble 2-Deburr any rough edges after tumbling

DAS  
21  
9-89

FEB 02 2018

### Job BOM

| Part / Item          | Component Name          | Quantity              | Operation             | Container |
|----------------------|-------------------------|-----------------------|-----------------------|-----------|
| M6061T6B00750X00.125 | 6061-T6 Bar .750 X .125 | 13.3200 ft (.0666 ea) | 90-Start up Operation |           |

### Part Specifications

Specifications could not be found.

*SO10026 - 20' pied*

*Cheque total pour la 300*

Plex 1/23/18 10:44 AM dart.lacelle.linda

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                                                                                                   |                                                                                                                                                                       |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                   |                                                                                                                                                                       |                                                                                                            |
|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____<br><br>Date : _____                                                  | DISPOSITION<br><br>Rework <input type="checkbox"/>                                                                                                                    | <div style="float: right; text-align: right;"> <b>Dart Aerospace Ltd.</b><br/>         1270 Aberdeen Street<br/>         Hawkesbury, ON K6A 1K7<br/>         CANADA<br/>         TEL.: 1 613 632-5200<br/>         Email: sales@dartaero.com<br/>         www.dartaerospace.com       </div> <div style="clear: both;"></div> <table style="width: 100%;"> <tr> <td style="width: 33%;">           tube <input type="checkbox"/><br/>           l Fab <input type="checkbox"/><br/>           hing <input type="checkbox"/><br/>           site <input type="checkbox"/> </td> <td style="width: 33%;">           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </td> <td style="width: 33%;">           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </td> </tr> </table> | tube <input type="checkbox"/><br>l Fab <input type="checkbox"/><br>hing <input type="checkbox"/><br>site <input type="checkbox"/> | Water Jet <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/><br>Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/><br>Quality <input type="checkbox"/><br>Other <input type="checkbox"/> |
| tube <input type="checkbox"/><br>l Fab <input type="checkbox"/><br>hing <input type="checkbox"/><br>site <input type="checkbox"/> | Water Jet <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/><br>Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/><br>Quality <input type="checkbox"/><br>Other <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                   |                                                                                                                                                                       |                                                                                                            |
|                                                                                                                                   |                                                                                                                                                                       | MRB (QSI042) Approval<br><br><br>Completed By<br><br><br>Lead hand / Supervisor<br>Approval Verification<br><br><br>QC / QA Coordinator<br>Approval                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                       |                                                                                                            |

**S036054**

Radius Block

**PART NO: D3601-1**

**Original Serial #: S036054**

**Revision: 01/27/18**

**Operation 01/27/18**

**Change No: 170866**

**Start up Operation**

| Root Cause                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | FAULT CATEGORY                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Other                                                                                                                                                                                                                                                                                                                                                                                                                             |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Environment <input type="checkbox"/><br>Design <input type="checkbox"/><br>Doc/Data <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Pre <input type="checkbox"/><br>Material <input type="checkbox"/><br>Internal Transport <input type="checkbox"/><br>Tribal Knowledge <input type="checkbox"/><br>LOA <input type="checkbox"/><br>Substation <input type="checkbox"/><br>Past Expiry Date <input type="checkbox"/><br>Misidentified <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/><br>Set-up <input type="checkbox"/><br>BOM/Route <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/><br>Inspection Incomplete/Unqualified <input type="checkbox"/><br>Contamination <input type="checkbox"/><br>Countersink <input type="checkbox"/><br>Cut Too Short <input type="checkbox"/><br>Instructions Incomplete/Unclear <input type="checkbox"/><br>Drill Holes <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/><br>Folio/Program <input type="checkbox"/><br>Grain <input type="checkbox"/><br>Weld <input type="checkbox"/><br>Wrong Stock Pulled <input type="checkbox"/><br>Out of Sequence <input type="checkbox"/><br>Off-set <input type="checkbox"/><br>Mislabeled <input type="checkbox"/><br>Fit/Function <input type="checkbox"/><br>Misaligned/off center <input type="checkbox"/>           |
| Cracks <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave <input type="checkbox"/><br>Cuffs <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Heat Treat <input type="checkbox"/><br>Wave/Twist in Tube <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/>                                                                                                                                                                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Positioned Wrong <input type="checkbox"/><br>Outside Dimensions <input type="checkbox"/><br>Over/Under tolerance <input type="checkbox"/><br>Part Incorrect <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Part Moved <input type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input type="checkbox"/><br>Misread <input type="checkbox"/><br>Turning Sequence <input type="checkbox"/> |
| OTHER : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                   |



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## Inventory

| Operation Number                                                           | Operation  | Serial Number | Job    | Master Unit Number | Quantity   | Weight   | Original Serial Number | Location             | Container | Status    | Added     | Special Comments | Label                                                                               | Supplier | Change No | Inventory Type |
|----------------------------------------------------------------------------|------------|---------------|--------|--------------------|------------|----------|------------------------|----------------------|-----------|-----------|-----------|------------------|-------------------------------------------------------------------------------------|----------|-----------|----------------|
| <b>Part Number: D3601-1 Revision: Radius Block</b>                         |            |               |        |                    |            |          |                        |                      |           |           |           |                  |                                                                                     |          |           |                |
| 180                                                                        | QC21-SA    | S036054       | 170866 |                    | 209 Ea     | 0        | S036054                | ST045                |           | Stock     | 1/27/2018 | *                |  |          |           | False          |
| <b>Operation Totals:</b>                                                   |            | <b>1</b>      |        |                    | <b>209</b> | <b>0</b> |                        |                      |           |           |           |                  |                                                                                     |          |           |                |
| <b>Part Totals:</b>                                                        |            | <b>1</b>      |        |                    | <b>209</b> | <b>0</b> |                        |                      |           |           |           |                  |                                                                                     |          |           |                |
| <b>Part Number: M6061T6B00750X00.125 Revision: 6061-T6 Bar .750 X .125</b> |            |               |        |                    |            |          |                        |                      |           |           |           |                  |                                                                                     |          |           |                |
| 100                                                                        | Receive Ft | S036053       | 170866 |                    | 3 ft       | 0        | S010026                | Start Up Machining-4 |           | Allocated | 1/27/2018 | *                |  |          |           | False          |
| <b>Operation Totals:</b>                                                   |            | <b>1</b>      |        |                    | <b>3</b>   | <b>0</b> |                        |                      |           |           |           |                  |                                                                                     |          |           |                |
| <b>Part Totals:</b>                                                        |            | <b>1</b>      |        |                    | <b>3</b>   | <b>0</b> |                        |                      |           |           |           |                  |                                                                                     |          |           |                |
| <b>Totals:</b>                                                             |            | <b>2</b>      |        |                    | <b>212</b> | <b>0</b> |                        |                      |           |           |           |                  |                                                                                     |          |           |                |

Plex 2/1/2018 12:27 PM dart.Gagnon.Michelle